



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

U/R

SAN
18-06-11

D3535-25

Job Sheet 179003



Part No: D3535-25

Job Qty: 10 ea

Part Name: Wearplate Center



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 16-638 DWG REV B U/R IPP Rev:A New Issue 07-02-15 JLM IPP Rev:B As per Rev B 07-08-31 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Waterjet		DL 18/06/12
100	Waterjet	10 pcs	6/22/18	6/22/18	0.00	0.67	Waterjet1		DL 18/06/12
110	QC	10 pcs	6/22/18	6/22/18	0.00	0.00	QC2 Waterjet-2		DL 18/06/12
120	QC	10 pcs	6/22/18	6/22/18	0.00	0.00	QC8-2		38
130	Brake NC	10 pcs	6/22/18	6/22/18	0.12	0.42	Brake NC 1		DL 18/06/12
140	QC	10 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
150	Powdercoat	10 pcs	6/22/18	6/22/18	0.00	0.17	Powdercoat3		DL 18/06/12
160	QC	10 pcs	6/22/18	6/22/18	0.00	0.00	QC3		38
170	Packaging	10 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1	FP002.	DL 18/06/12
180	QC21-SA	10 Ea	6/22/18	6/22/18	0.00	0.00	QC21		DL 18/06/12

M 136370

START: 10:00

OUT: 3:00

FINISH: 10:30

JUL 01

2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	5.5000 sf (.55 ea)	90-Start up Operation	5055657

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	6	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	1.885inches ± 0.010	1.895 1.875		
2	Wearshoe	1.937inches ± 0.010	1.947 1.927		
3	Wearshoe	1.450inches ± 0.010	1.460 1.440		
4	Wearshoe	5.450inches ± 0.010	5.460 5.440		
5	Wearshoe	10.900inches ± 0.010	10.910 10.890		
6	Wearshoe	16.350inches ± 0.010	16.360		

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	
NCR No. _____		Suspected Unapproved ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	
Date: _____		Step #: _____		QTY Effective: _____	
Description Work Order Deviation				Disposition	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause					
Environment		No Re-verification			
Design		Operator			
Doc/Data		Offset/Setup			
Equip/Tooling		Supplier			
Handling/Pre		Training			
Material		Use for Testing			
Internal Transport		Poor Information			
Tribal Knowledge		Rushing			
LOA		Product Improvement			
Substation		Process Improvement			
Past Expiry Date		Manufacturing Process			
Misidentified		Past Due			

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www.dartaerospace.com

Date: 06/12/18

DART AEROSPACE
Container No: S080560
Part: D3535-25
Job No: 179003
Serial No/Batch: S080560
Revision: B
Inspector:
Exp Date:
Instructions: URF16-638

Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐
Positioned Wrong ☐
Outside Dimensions ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

			16.340
7	Wearshoe	21.800inches ± 0.010	21.810 21.790
8	Wearshoe	0.188inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.193 0.187
9	Wearshoe	12.750inches ± 0.010	12.760 12.740
10	Wearshoe	6.750inches ± 0.030	6.780 6.720
11	Wearshoe	6.000inches ± 0.030	6.030 5.970
12	Wearshoe	0.300inches ± 0.010	0.310 0.290
13	Wearshoe	0.300inches ± 0.010	0.310 0.290
14	Wearshoe	0.038inches ± 0.010	0.048 0.028

Plex 6/11/18 3:44 PM Dart.lajeunesse.marie

DART

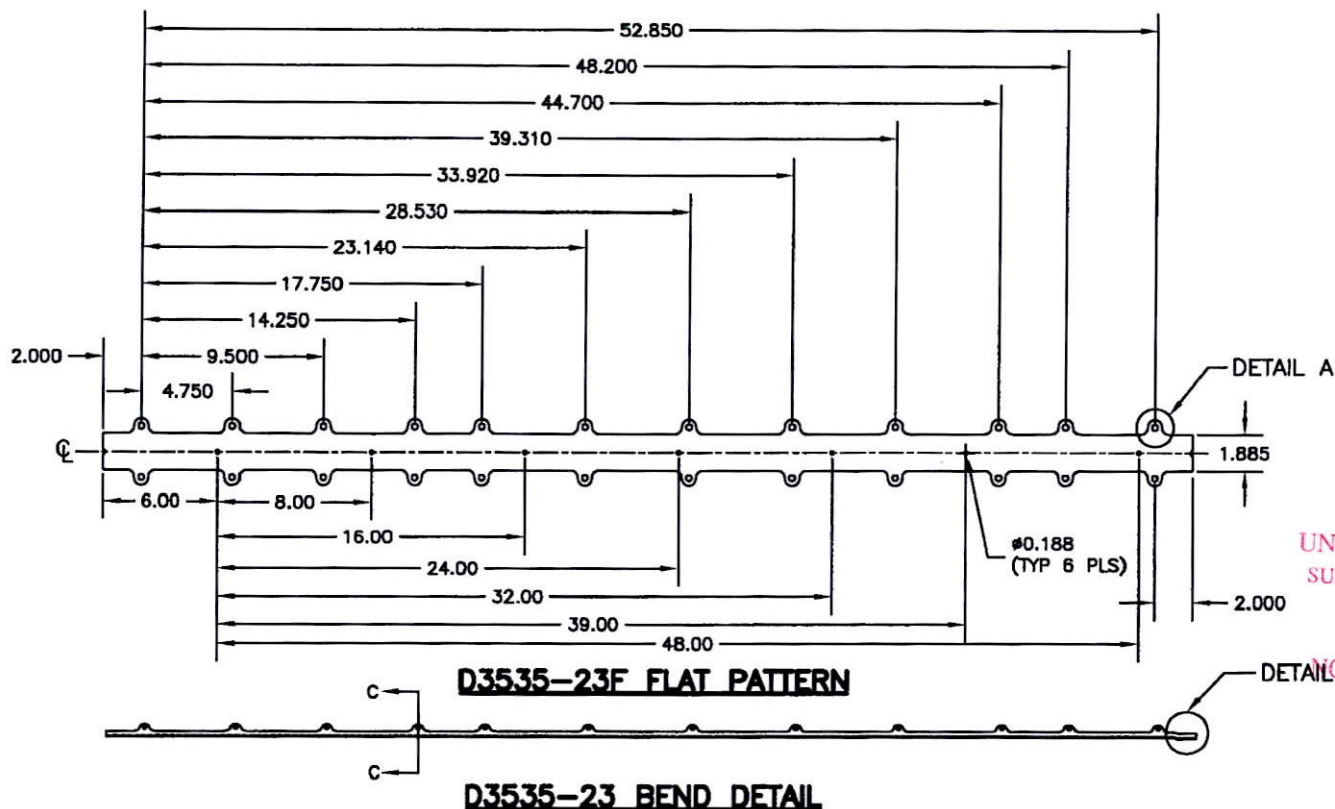
RELEASED

07.04.17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOB 17900345
18.06.18

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 7
		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



UNDER REVIEW

URF 16-638 AJ5 16.08.31

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

